



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4469-1**Job Sheet 191096****Part No:** D4469-1**Job Qty:** 4 pcs**Part Name:** Outer Skin Lower Door**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/21/19**Job Tracking No:****Due Date:** 2/25/19**Created By:** Jason Leroux**Type:** SOLD**Description:**

Note: DWG REV D IPP REV:A 11.12.12 new issue DD verf:EC IPP REV:B 12.05.17 as per revpb1 DD verf:EC IPP
Rev:C 12.10.09 per dwg revB DD VERF:JLM IPP REV:D 13.02.11 PER DWG REV.C DD VERF:JLM IPP
REV:E 14.03.27 PER DWG REV.D DD VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		2/25/19	0.00	1.26	Waterjet - Flow		Dec 19/03/04
110	QC 2	4 pcs		2/25/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		Dec 19/03/04
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

Plex 2/21/19 11:21 AM dart.leroux.jason

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

125 QC 8	4 pcs	2/25/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	DAS
				QC 8 - 9	40
				QC 8 - 68	9-89
				QC 8 - 67	
				QC 8 - 47	
130 Handfinish - 1-1 Chemical-B4B	4 pcs	2/25/19	0.00 0.62	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/03/06
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				140 QC 7	4 pcs
QC 7 - 13					
QC 7 - 14					
				Plex 2/21/19 11:21 AM dart.leroux.jason	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	DAS
				QC 7 - 68	19-03-11 68
				QC 7 - 50	9-89
				QC 7 - 67	
150	Spray Paint - 2 - B4B	4	2/25/19	0.00 0.90	Spray Paint - 1 - B4B
	pcs				Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
160	QC	4	2/25/19	0.00 0.00	QC14
	pcs				MAR 11 2019
170	Packaging 3-1 - Stock - B4B	4	2/25/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:					

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
180 QC 21 - SA	4 pcs	2/25/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	mod. 19.03/12
				QC 21 - SA - 53	
Part Op 100 - 1-Cut as per Dwg Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 125 - QC8- Inspect parts - second check 130 - Chemical Conversion Coat per QSI005 4.1 140 - QC7-Inspect Chemical Conversion Coat 150 - Spray Paint / NDT Room - Prime tempo grey as per dwg (note 2) Batch: <u>5135773</u> 160 - QC14- Inspect Spray Paint 170 - Identify as per dwg & Stock Location: _____ LOCATION : GA 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.032	6061-T6 Sheet 0.032"	17.8520 sf (4.463 ea)	100-Waterjet - Flow - 1	<u>5152/47</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M6061T6S.032	18	104	0	
Part Specifications					
Specifications could not be found.					

 DAS
 70
 9-89

Plex 2/21/19 11:21 AM dart.leroux.jason

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Store/Packaging ☐	Supplier Quality ☐							
Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐																					
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐																					
Large Fab ☐	Finishing ☐	Store/Packaging ☐	Supplier Quality ☐																					
Date : _____		Sequence # _____		MRB (QSI042)																				
Description Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 819 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 03/04/19		Completed By 																						
		Lead hand / Supervisor 																						
		QC / QA Coordinator 																						
		Root Cause <table style="width:100%;"> <tr> <td>Operator ☐</td> <td rowspan="6" style="vertical-align: middle; text-align: center;"> Container No: S158721 Part: D4469-1 Job No: 191096 Serial No/Batch: S158721 Revision: Inspector: Exp Date: Instructions: Various ST's </td> </tr> <tr><td>Manufacturing Process ☐</td></tr> <tr><td>Equip/Tooling ☐</td></tr> <tr><td>Handling/Preservation ☐</td></tr> <tr><td>Material ☐</td></tr> <tr><td>Product Improvement ☐</td></tr> <tr> <td>Process Improvement ☐</td> <td></td> </tr> <tr> <td>Human Factors ☐</td> <td></td> </tr> </table>				Operator ☐	Container No: S158721 Part: D4469-1 Job No: 191096 Serial No/Batch: S158721 Revision: Inspector: Exp Date: Instructions: Various ST's	Manufacturing Process ☐	Equip/Tooling ☐	Handling/Preservation ☐	Material ☐	Product Improvement ☐	Process Improvement ☐		Human Factors ☐									
Operator ☐	Container No: S158721 Part: D4469-1 Job No: 191096 Serial No/Batch: S158721 Revision: Inspector: Exp Date: Instructions: Various ST's																							
Manufacturing Process ☐																								
Equip/Tooling ☐																								
Handling/Preservation ☐																								
Material ☐																								
Product Improvement ☐																								
Process Improvement ☐																								
Human Factors ☐																								
<table style="width:100%;"> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Grain Direction</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Weld</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Drill Holes</td> <td>☐ Wrong Stock Pulled</td> </tr> <tr> <td></td> <td>☐ Fit/Function</td> <td>☐ Out of Sequence</td> </tr> <tr> <td></td> <td></td> <td>☐ Off-set/Set-up</td> </tr> </table>		☐ Crimp/Kink/Ripple/Wave/Twist	☐ Broken/Damage/Defect	☐ Grain Direction	☐ Marks/Chatter	☐ Incomplete/Unclear Instructions	☐ Weld	☐ Mislabeled	☐ Drill Holes	☐ Wrong Stock Pulled		☐ Fit/Function	☐ Out of Sequence			☐ Off-set/Set-up	<table style="width:100%;"> <tr><td>☐ Positioned Wrong</td></tr> <tr><td>☐ Outside Tolerance</td></tr> <tr><td>☐ Drawing</td></tr> <tr><td>☐ Finish</td></tr> <tr><td>☐ Part Lost/Missing</td></tr> <tr><td>☐ Misread</td></tr> </table>		☐ Positioned Wrong	☐ Outside Tolerance	☐ Drawing	☐ Finish	☐ Part Lost/Missing	☐ Misread
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Broken/Damage/Defect	☐ Grain Direction																						
☐ Marks/Chatter	☐ Incomplete/Unclear Instructions	☐ Weld																						
☐ Mislabeled	☐ Drill Holes	☐ Wrong Stock Pulled																						
	☐ Fit/Function	☐ Out of Sequence																						
		☐ Off-set/Set-up																						
☐ Positioned Wrong																								
☐ Outside Tolerance																								
☐ Drawing																								
☐ Finish																								
☐ Part Lost/Missing																								
☐ Misread																								
Other/Details: _____																								

